

Work Order ID 58942

Thursday, May 20, 2010 10:30:29 AM



Page 1

Item ID: D350-607-043

Accept



Setup Start

Revision ID:

Item Name: Heli-Utility-Basket

Stop



Start Date: 5/25/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*AK*Date: *10-5-20* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D350-607-1

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-043 CHG005

*5 10/06/07**10-6-1 CL 10/06/02*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-6-1 SP

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D350-607
Seal Support Gusset with Sikaflex -291
Batch: *11/35/9*
Exp Date: *10/9/83**ES 10/06/07 @*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/20/06/07

①

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10.6.1 SP

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

5/20/06/07

①

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D350-607-043

Accept



Setup Start



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Item Name: Heli-Utility-Basket

Stop



Start Date: 5/25/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-607-043 Location: <u>BR</u>								
170 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Rec 4

10-50-7 SP

10/06/08

MF

10-5-8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, May 20, 2010 10:30:34 AM

Page 1

Work Order ID: 58942

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket

Comments: IPP Rev:E as Per DSI9318 06-01-24 JLM
IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as
per ecn10-545 DD 10.04.19 verified by:EC

Start Date: 5/25/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
D2728-3		Manufactured	No			110	Each	0.0000	2			
Dart Logo label												
D350-607-241		Manufactured	No			140	Each	0.0000	1			
Basket Clamp Assembly												
D2022-101		Manufactured	No			110	Each	237.0000	5			
Spacer												

Location	Loc Qty	Loc Code
ST504	237	
45885	37	
50746	100	
52325	100	

D2221		Manufactured	No			110	Each	0.0000	1			
350 Basket Base												
D2258-200		Manufactured	No			110	Each	6.0000	1			
Placard 2001b												

Location	Loc Qty	Loc Code
ST505	6	
56229	6	
	14.0000	

D2332-041		Manufactured	No			110	Each	14.0000	1			
Lid Prop Assembly 6.69" long												

Location	Loc Qty	Loc Code
ST512	14	
57344	4	
57645	10	

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W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 58942



Parent Item: D350-607-043



Parent Item Name: Heli-Utility-Basket

Start Date: 5/25/2010

Required Date: 6/10/2010

Comments: IPP Rev:E as Per DSI9318 06-01-24 JLM
 IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as
 per ecn10-545 DD 10.04.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
D2530		Manufactured	No			110	Each	9.0000	1			
Handle Weldment												

Location	Loc Qty	Loc Code
ST506	9	
57736	1	
57964	2	
58428	6	

10-6-1

D2535		Manufactured	No			110	Each	142.0000	2			
Spring												

Location	Loc Qty	Loc Code
ST504	142	
56355	42	
58331	100	

10-6-1

D2537		Manufactured	No			110	Each	57.0000	2			
Bushing												

Location	Loc Qty	Loc Code
ST504	57	
57722	17	
58429	40	

10-6-1

D2931		Manufactured	No			110	Each	862.0000	2			
Bumper												

Location	Loc Qty	Loc Code
ST504	862	
46064	862	

10-6-1

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Page 3

Work Order ID: 58942

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Parent Item Name: Heli-Utility-Basket






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 IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as
 per ecn10-545 DD 10.04.19 verified by:EC

Start Date: 5/25/2010

Required Date: 6/10/2010

Start Qty: 1:00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
D2989-041		Manufactured	No			110	Each	0.0000	1			
												
Basket Lid Assembly												
D2989-043		Manufactured	No			110	Each	0.0000	1			
												
Basket Lid Assembly												
AN3-16A		Purchased	No			110	Each	65.0000	2			
												
Bolt												
<div> <div>Location</div> <div>ST352</div> <div>113845</div> <div>114523</div> </div> <div> <div>Loc Qty</div> <div>65</div> <div>45</div> <div>20</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>												
AN4-13A		Purchased	No			110	Each	119.0000	2			
												
Bolt												
<div> <div>Location</div> <div>ST351</div> <div>114523</div> </div> <div> <div>Loc Qty</div> <div>119</div> <div>119</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>												
AN4-22A		Purchased	No			110	Each	228.0000	7			
												
Bolt												
<div> <div>Location</div> <div>ST359</div> <div>111965</div> <div>114523</div> </div> <div> <div>Loc Qty</div> <div>228</div> <div>128</div> <div>100</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>												

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket


Comments: IPP Rev:E as Per DSI9318 06-01-24 JLM
IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as
per ecn10-545 DD 10.04.19 verified by:EC

Start Date: 5/25/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
AN5-17A		Purchased	No			110	Each	151.0000	4			
											10.6.15	
Bolt												

Location

Loc Qty

Loc Code

ST323

46

114324

46

ST339

105

113538

5

114330

100

MS20600-AD4W3

Purchased

No

110

Each

1,789.000

2



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

1789

106375

3

107939

822

111636

964

AN960JD416 NRS114900463J

Purchased

No

110

Each

0.0000

14



Washer

AN960JD416L

Purchased

No

110

Each

413.0000

2



Washer

Location

Loc Qty

Loc Code

ST346

413

110153

413

AN960JD516 NRS114900563J

Purchased

No

110

Each

0.0000

4



Washer

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 58942

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket

Comments: IPP Rev:E as Per DSI9318 06-01-24 JLM
 IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as
 per ecn10-545 DD 10.04.19 verified by:EC

Start Date: 5/25/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
AN960JD8	NAS1149DV8321	Purchased	No			110	Each	0.0000	2			
Washer												
NAS1515H4		Purchased	No			110	Each	151.0000	2			
Washer												
<div> <div>Location</div> <div>ST277</div> <div>111294</div> <div>111525</div> </div> <div> <div>Loc Qty</div> <div>151</div> <div>53</div> <div>98</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>												
AN970-4		Purchased	No			110	Each	121.0000	4			
Washer												
<div> <div>Location</div> <div>ST349</div> <div>112991</div> </div> <div> <div>Loc Qty</div> <div>121</div> <div>121</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>												
MS21042L3		Purchased	No			110	Each	1,862.000	2			
Nut												
<div> <div>Location</div> <div>ST300</div> <div>113537</div> <div>113644</div> <div>114523</div> <div>114718</div> </div> <div> <div>Loc Qty</div> <div>1862</div> <div>20</div> <div>342</div> <div>1000</div> <div>500</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>												

Thursday, May 20, 2010 10:30:34 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Thursday, May 20, 2010 10:30:34 AM

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Parent Item: D350-607-043

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Comments: IPP Rev:E as Per DSI9318 06-01-24 JLM
 IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as
 per ecn10-545 DD 10.04.19 verified by:EC

Start Date: 5/25/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
MS21042L4		Purchased	No			110	Each	2,705.000	9			
												
Nut											10-6-12	

Location	Loc Qty	Loc Code
ST139	2	
111827	2	
ST300	2703	
113422	80	
114523	1615	
114718	1000	
9063	8	

MS21042L5

Purchased

No

110

Each

532.0000

4

Nut

Location	Loc Qty	Loc Code
ST300	532	
113523	26	
113537	3	
114108	3	
114437	100	
114449	400	

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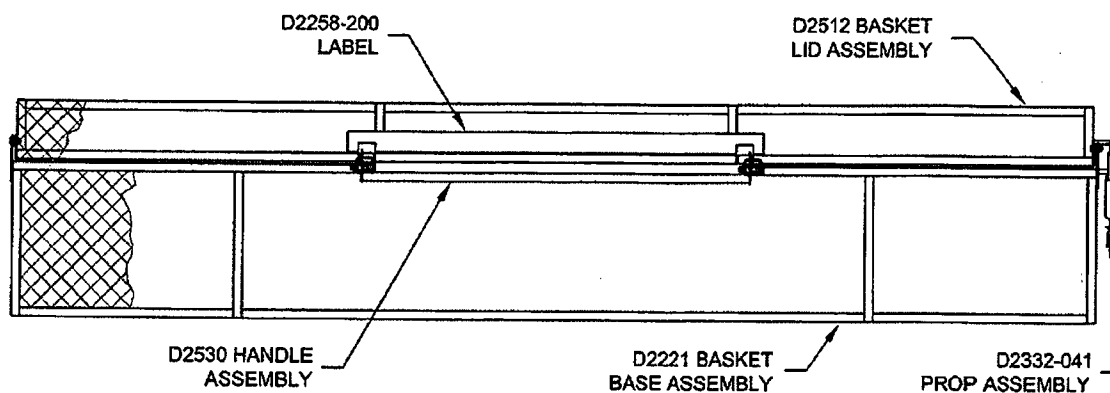
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

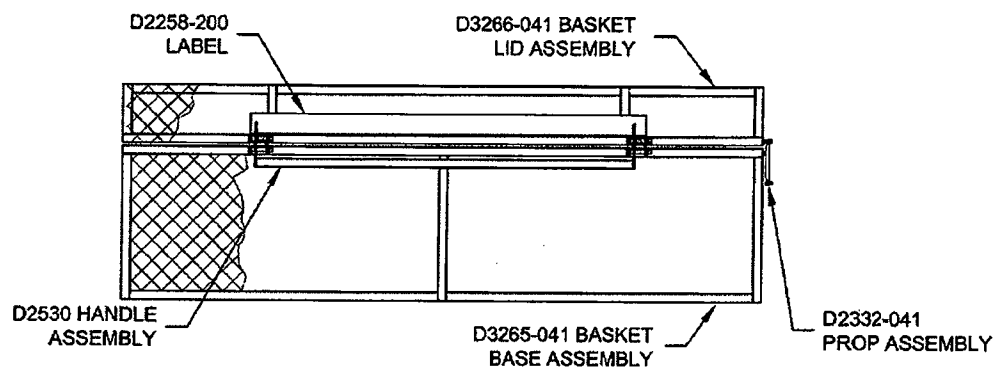
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

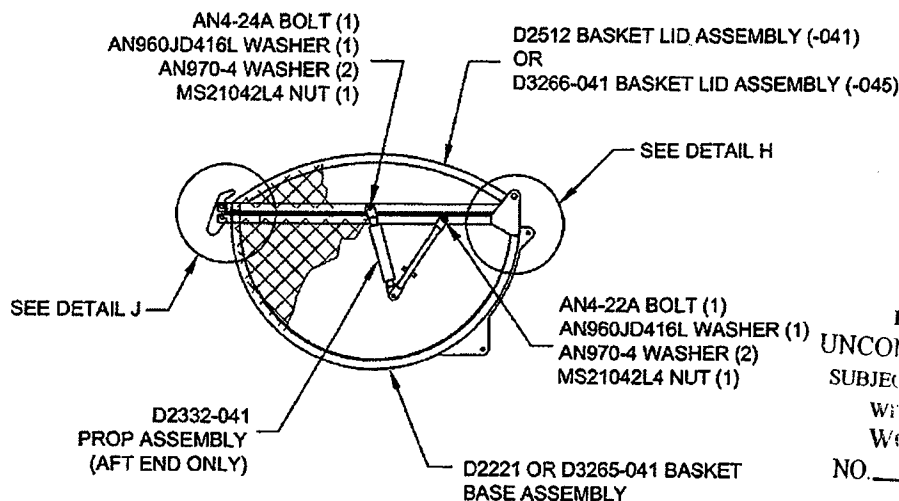
NOTE: Date & initial all entries



D350-607-041 HELI-UTILITY- BASKET™



D350-607-045 HELI-UTILITY- BASKET™



VIEW C-C
PROP ARM DETAIL

Figure 5 – Basket Replacement Parts

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SHOP COPY
RETURN
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58942

10-5-20

Revision: **A**
Date: 10.03.10

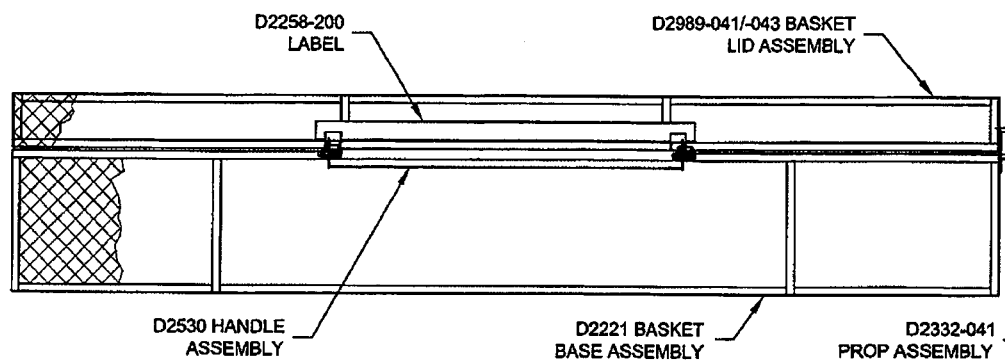
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

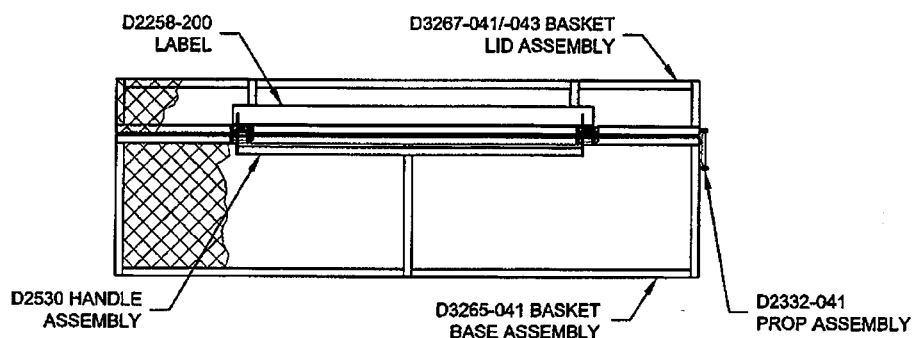
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

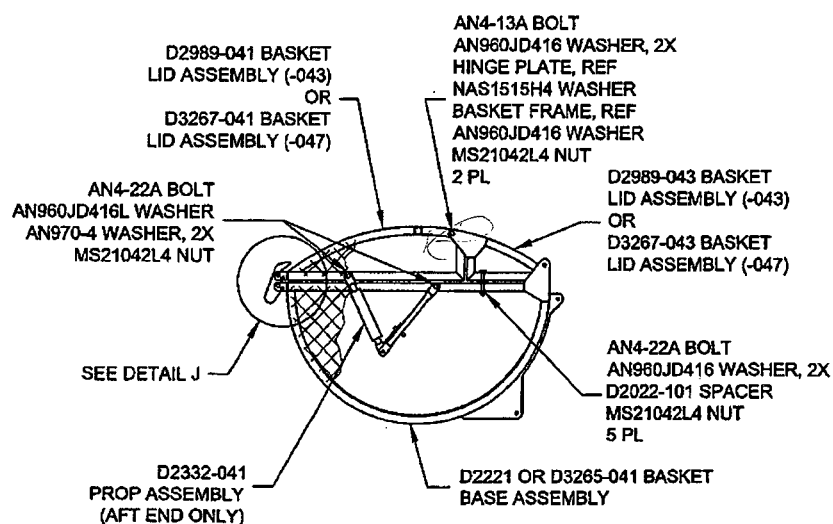
NOTE: Date & initial all entries



D350-607-043 HELI-UTILITY- BASKET™



D350-607-047 HELI-UTILITY- BASKET™



VIEW C-C
PROP ARM DETAIL

Figure 6– Basket Replacement Parts

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Revision: **A**

Date: 10.03.10

w/b 58942

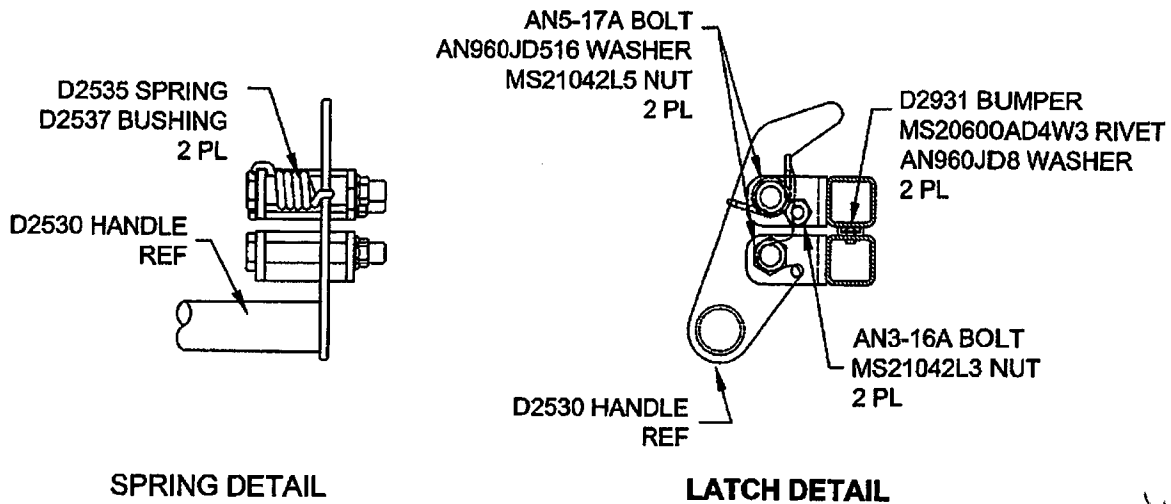
W/O:		WORK ORDER CHANGES					
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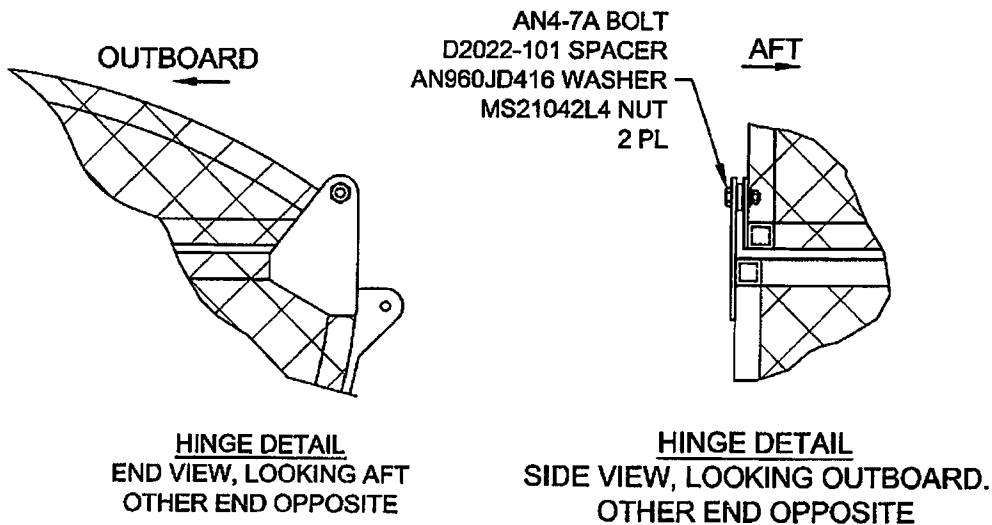
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DETAIL J:
HANDLE WELDMENT**



**DETAIL H:
HINGE**

Figure 7 – Basket Replacement Parts

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Revision: **A**
Date: 10.03.10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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